Work Orde		918	A ·	*9891	8*	مبر 		Page 1	
Item ID: Revision ID: Item Name:	646.9710 Body	646.9710// B98918	INC.	Accept	"N9กักก4ก	1100*	Setup Starr	. 10'21	
Start Date: Required Date: Reference:	4/05/13 4/05/13	Start Qty: 34,00 Req'd Qty: 34,007	*34* *34*		Cust Item ID: Customer:				,
Approvals:	Process Pl	and the second s	ate: /3-04-0	Tooling:	Date:	 -	Run Star	"INK I"	
Sequence ID/ Work Center II Draw Nbr 646.9700		Operation Description vision Nbr		Set Up/ Run Hours	Tool ID Tool #	Plan Acce Code Qty	pt Reject Qty	Reject Insp. Number Stamp	
*100 *100* Bandsaw	-	BAND SAW Memo Cut Blank at 7.42	:5"	0.00	13/05/21	5)		
*110 *110* HAAS I HAAS CNC vertica	Il machine #1	HAAS CNC VERTICAL MA Memo 1-Machine per fo DWG REV:/ FOLIO REV:/	io FB130	0.00 0.00	13/05/22	<u>.51</u>			PB
		2- deburr and bre	ak all sharp edges		•	i			·

,			
NCR:	Yes	1	No
NCA.	163		INU

WORK ORDER NON-CONFORMANCE / UPDATE

1 1/2		464	ı
DQA: Sull	Date:/3/09/67		
* * * i	, ,		
Closed: AH	Data: 12/91/	^	

										QA Closed:	Date:	12/9/6			
Work Orde	er: <u>98</u> 9	1/8	J	1	DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	No. <u>646</u> No. <u>13</u> -	971			Rework Scrap Use-as-is Work Order Update	T	N herm	Skid-tube 1 Nachining 7 Oforming 2 Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty	l	ption of work order update	Initi Chief	Eng	Des	ction cription	Sign & Date	Verification	QC Inspector			
Doc/Data Equip/Tooling, Operator Material Setup Other Process Supplier Training Unapproved	13/be/10		1	R.C.	slot are .030 off the part. I retake my origin was off no est luch forms Done	0A3	2 m2	replace Batch	MQ55\$4	3/06/16	0AS 16 13/06/2	022012 03/04/12			
опаррточес	Ļ l		1	L	F	AULT C	ATEG	ORY		, I					
Landi	ng Gear				General										
	Bending Centre Non- Cracks Crushed/ Cuffs Heat Tree	'Crimped	ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Ins Ins Ma	rdware spectio	on Incomplete ons Incomplete nance	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
	Inspectio		Tube		Cut Too Short	HI	isread		f	Power Loss/	· -	Other			
	Ripples in	•			Drill Holes	Off	fset		_	Pl. Short	<u> </u>	heat whe			
	Torque V	Vaves in I	Extrusio	n _	Drawing	Out of		Out of Calibration			Dato Pelee stati Res				
	Turning S	Sequence			Finish	∐o _u	Out of Sequence								
	Wave/Tw	vist in Tul	oe e		Folio	Ou	itside l	Dimensions							

Hand Finishing

March-28-13 10:43:03 AM Accept Item ID: 646.9710 Setup Start **Revision ID:** Stop Item Name: Body Start Qty: 34.00 Start Date: 4/05/13 Cust Item ID: Customer: Required Date: 4/05/13 Req'd Qty: 34.00 Reference: Run Process Plan: Tooling: Date: Date: Approvals: Stop CDate: Date: SPC (Y/N): QC: Tool ID Tool # Plan Reject Reject Sequence ID/ Set Up/ Accept Operation Qty Qty Number Stamp Code Work Center ID Description **Run Hours** and 13/05/22 0.00 QC2- Inspect parts off machine FAI/FAIB 120 51 *120* 0.00 OC Memo Quality Control 0.00 QC8- Inspect parts - second check 130 O 13/06/12 · QC . 0.00 Memo Quality Control 0.00 131 *121* 0.00 HandFinish Memo

Clean & remove markings

NCR: Y	es / No				WORK ORDER NON-	CONFO	RMANCE / UF	PDATE			•			
	•								QA Closed:	Date:	•			
Work Orde	r:	·			DISPOSITION			AGAINST DE	EPARTMENT,	/PROCESS				
					Rework]	Skid-tube	Crosstube	}	Water Jet	Engineering			
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- 14					Use-as-is] Th	ermoforming	Finishing	Rec/Sto	re/Packaging	Other			
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-					<u>.</u> .									
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-	Centre No	ot Conce	ntric to C	o/s	BOM/Route	⊢	ware	<u> </u>	Over/Under		Temperature/Cure			
-	Cracks			-	Broken/Damaged	—	ection Incomplete	<u></u>	Part Incorred	—	Weld			
L	Crushed/	Crimped			Burrs	-	uctions Incomplete	:/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
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L	Heat Trea	at		_	Countersink	Misl	abeled	L	Positioned V	Vrong	_			
<u> </u>	Inspectio		Tube		Cut Too Short	Mis	ead	Ľ	Power Loss/	Surge	Other			
ļ	Ripples in	Bend			Drill Holes	Offs	et			· ·				
ļ	Torque W	Vaves in E	extrusion	·	Drawing	Out	of Calibration	•						
	Turning S	•		L	Finish	Out	of Sequence							
Wave/Twist in Tube Folio Outside Dimensions														

DQA:

Date:

Quality Control

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE					,
							_				QA	Closed:	Da	ite:	
Work Orde	or.				·	DISPOSITION				AGAINST D	EPAF	RTMENT,	/PROCESS		
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NCR I	۷o.					Work Order Update			Large Fab	Composite			Supplier		
Root ·			<u> </u>	T	Descri	tion of work order update		I Initial	Ac	tion	S	Sign &			
Cause		Date	Step	Qty	c	or Non-conformance	Cł	nief Eng	Desc	ription		Date_	Verificatio	n_	QC Inspector
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		Cuffs				Contamination		Mainte	nance		Par	rt Moved			
		Heat Trea	at			Countersink		Mislabe	ied	Ĺ	Pos	sitioned V	Vrong		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Pov	wer Loss/	Surge		Other
ļ		Ripples in	n Bend			Drill Holes		Offset							

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ordo <i>March-28-13 10</i>		918		*989	18*			Page 4
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	646.9710 Body 4/05/13 4/05/13	Start Qty: 34.00 Req'd Qty: 34.00	*34* *34*	Accept	*N9000401 Cust Item ID: Customer:	nn* s	etup Start Stop	*NS1* *NS2*
Approvals:	Process Pla		Date:		Date: Date:	R 	aun Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* SprayPaint SprayPainting	D		5 4.2 ER DWG, SEE NOTE #2 4860-50 PRIMER BATC		_	an Accept ode Qty		Reject Insp. Number Stamp
170 *170* QC Quality Control		QC Inspect Spray Pair	nt	0.00 5W		<u>SI</u>	· · - <u>-</u>	
*180 *180* Packaging		Identify as per dwg & Sto Memo		0.00 0.00 2-120 BY STAMPING P#	AND PEV***	5/x	(Y	1. ND. 13-08-14

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

in the state of th

Packaging

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											DQ/	\: Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORI	MANCE / UPI	DATE				•
		_									QA Closed	d: Da	ate:	· · ·
Work Orde	eri:					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
Work Ord	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	: [Engineering
Part f	Vo.					Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor	$\boldsymbol{\vdash}$	Quality
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Root]		Descri	ption of work order update		nitial	Act	tion	Sign &	Ţ		·
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		Bending				Bend		Grain			Ovalized			Pressure/Forced
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Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DQA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Date: Tooling: Date: ___ Process Plan: Approvals: Stop SPC (Y/N): QC: Date: Date:

Page 5

Tool # Plan Tool ID Reject Reject Sequence ID/ Set Up/ Accept Insp. Operation Number Stamp Work Center ID Run Hours Code Qty Qty Description QC21- Final Inspection - Work Order Release 0.00 190

100 0.00 QC Memo

MUT 13-08-15 P(13-8.15 Quality Control

NCR: Y	es / No				WORK ORDER NON-	100	VFORM	MANCE / UPI	DATE			•
										QA Closed:	Da	ite:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,		
Part N	lo				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor.	Quality
NCR N	lo				Work Order Update		Large Fab Composite			Rec/Store/Packaging Supplier		
Root				Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	n QC Inspector
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-	Cracks			<u> </u>	Broken/Damaged		•	on incomplete	<u> </u>	Part Incorred		Weld
	Crushed	Crimped/		<u> </u>	Burrs			ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\perp	Mainte		<u></u>	Part Moved		
	Heat Tre			oxdapsilon	Countersink		Mislabe		<u> </u>	Positioned W	Ŭ I	
		on Strip in	Tube		Cut Too Short		Misread	i	Ĺ	Power Loss/:	Surge	Other
	Ripples i			<u> </u>	Drill Holes		Offset					
	Torque V	Vaves in I	Extrusio	n j	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

98918

Parent Item:

646.9710

Parent Item Name:

Body

Start Date: 4/05/13

Required Date: 4/05/13

Page I

Start Qty: 34.00

Required Qty: 34.00

~		
Com	me	nts:

IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Comments													
	· 												_
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued .	Status
M7075T6B5.000X1.000	-	Purchased	No			100	ť	5.4987	0.62	22.189474	1		<u> </u>

7075-T6 BAR 5.000" X 1.000"

Loc Qty Loc Code **Location** 5.4987 MAT049 5.4987 123611

MR5554 X33.15 or 13/05/21

											DQA:	Date	e:
NCR: Y	es / No					WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	0.6		•
			<u>-</u>		_						QA Closed:	Date	<u></u>
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					ı	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				ı	Scrap	Scrap Machining Small Fab				Pro	d. Eng. Coor.	Quality
						Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Work Order Update]		Large Fab	Composite		Supplier	
Root	·		<u> </u>	Desc	rip	tion of work order update	Ī	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		0	r Non-conformance	CH	nief Eng	Desc	ription	Date	Verification	QC Inspector
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Landir 1	g Gear			_	_	General	_	1		_	-	_	- .
}	Bending					Bend	\vdash	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
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}	Cracks			-		Broken/Damaged	\vdash	- 1	on Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld
	_	I/Crimped			-	Burrs	\vdash	-1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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	Heat Tre				_	Countersink	\vdash	Mislabe		 	Positioned V		¬
		on Strip in	Tube	-	_	Cut Too Short	<u> </u>	Misread		L	Power Loss/	Surge	Other
}	Ripples			L	\neg	Drill Holes	\vdash	Offset					
	_	Waves in I		ր Լ	\dashv	Drawing	\vdash	-{	Calibration				<u>,</u>
l l	Turning	Sequence	1	1	1	Finish	1	I Out of 9	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

	I FA I C T L					
	ENUIN	IEERING CHANGE NE	HICL NO.	02744	SHEET	ı OF 1
APICA	DWG		':N/C PREPARED BY	·	DATE: 01/07/10 EF	FECT ON DWG INC. ØUNINC.
INDUSTRIES,	INC. DWG	TITLE	CUTTER S	UB ASSY		
	APPROVED	BY, ENGR	Aconst In	30 OC // 1/2	HULLERON EFF: NEXT	ORDER
TRANSACTION CODES A-ADD C-CRE R-REVISE D-DEL	ALE LIVE LOOP	N: REWISED SCREW LENG	TH, CHANNEL W	TDTHS & DIMEN		
SHEET 2, ZON	E C6, IS:	SHEET	5, ZONE C2, IS	<u>, </u>	7 -(IS)	
13	X450° 2PL-	\ \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	3.20	702	750 985 (600' - R.750	x 300, LAb
3 R 601.3157	12	SCREW		MSSZO	039-0818	<u>'</u>
	.9701			143270	77 0010	
F/N TC PART NUM	···	DESCRIPTION		МА	TERIAL/SPECIFICATION	
DOCUMENTS EFFEC		☐ INSTALL INSTRUC 図 I	CA D FMS X BI	CHANGE CATE	SORY DEP DEVIEW BEOW	

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② 2PL
3 6PL
4 12PL
6 6PL

646.9701

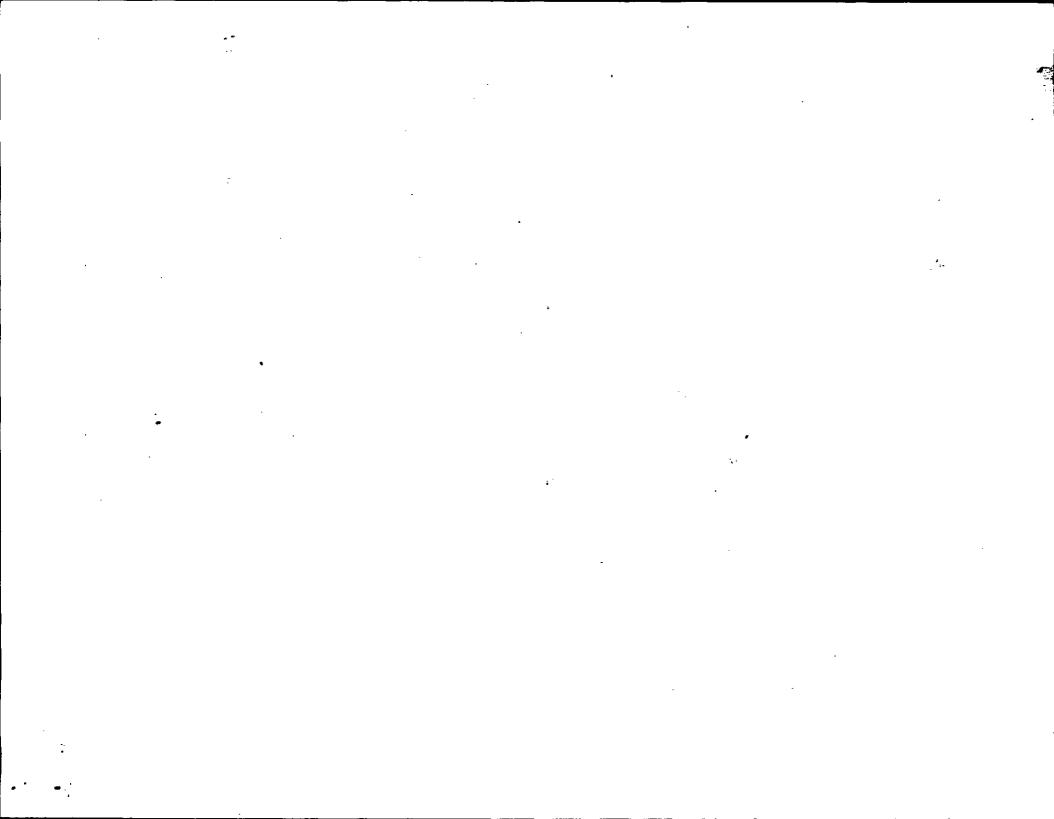
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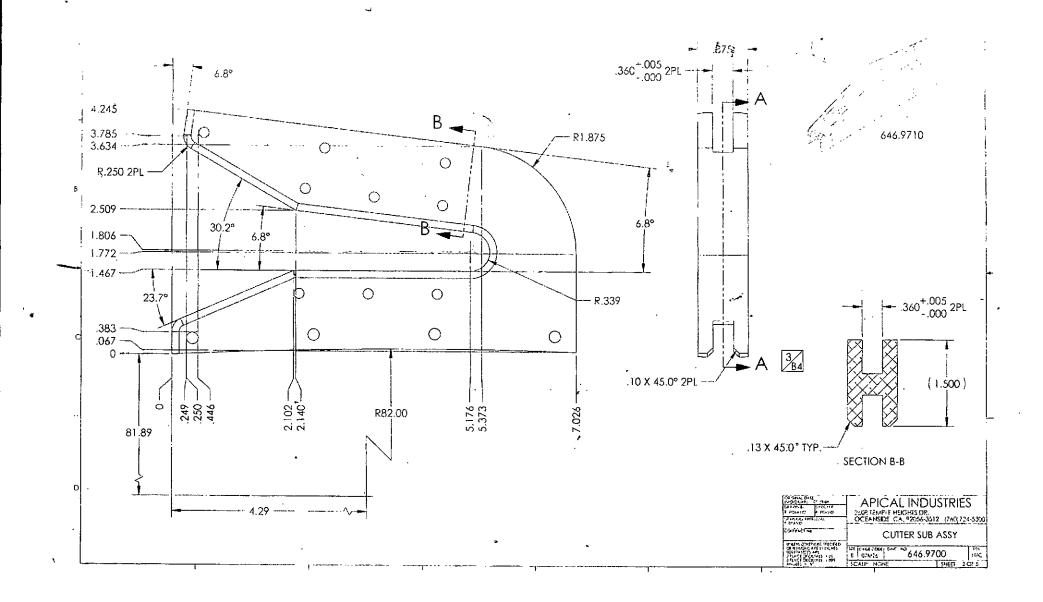
- (2) MATERIAL ALUMINUM 7075 T651 PER AMS/QQF4 2507/2
- ZN FINISH, HARD ANODERE IAW MA, A-8625 TYPE III. CLASS 2, COLOR BLACK: CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-7357/J TYPE LCLASS N. 1-2 MIL MAX
- MATERIAL, AISI AZ TOOL STEEL CONDITION: ANNEATED POST PROCESS: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS
- A FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N. 1-2 MIL MAX
- 5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6. IDENTIFY IAW MPP 120
- APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- (A) CUITING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

UNINCORPORATED ECN(s)

02744.

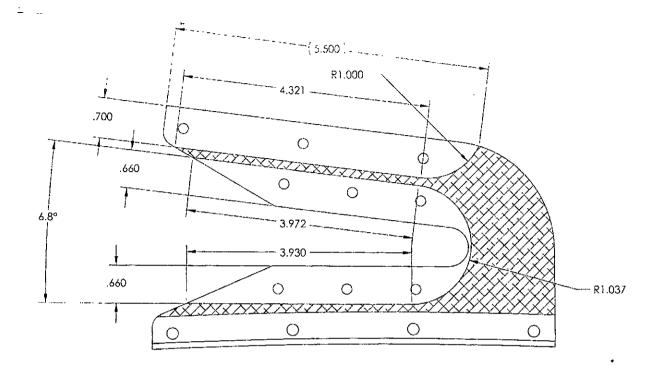
	C Note Co. Inc. Section of the Control of the Cont			acidenti ilici	CUTTER SUB ASSY			
	646,96	00	7 10		2406 TEMPLE HEIGHTS OR		(750)724-5300	
,	NEXT AS	5Y (S	Owice Owice	141 [M] 1-17 86 35 64 11 10 10 10 10 10 10 10 10 10 10 10 10 1	APICA	L INDUS	TRIES	
	GIY	**51	FIND •	PART =	DESCRIPTION PARTS LIST	TANL	SPEC.	
	JD	\leq		646,9701	CUTTER SUB ASSY			
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		12	4	631,2764	WASHER	Total Control of Con-		
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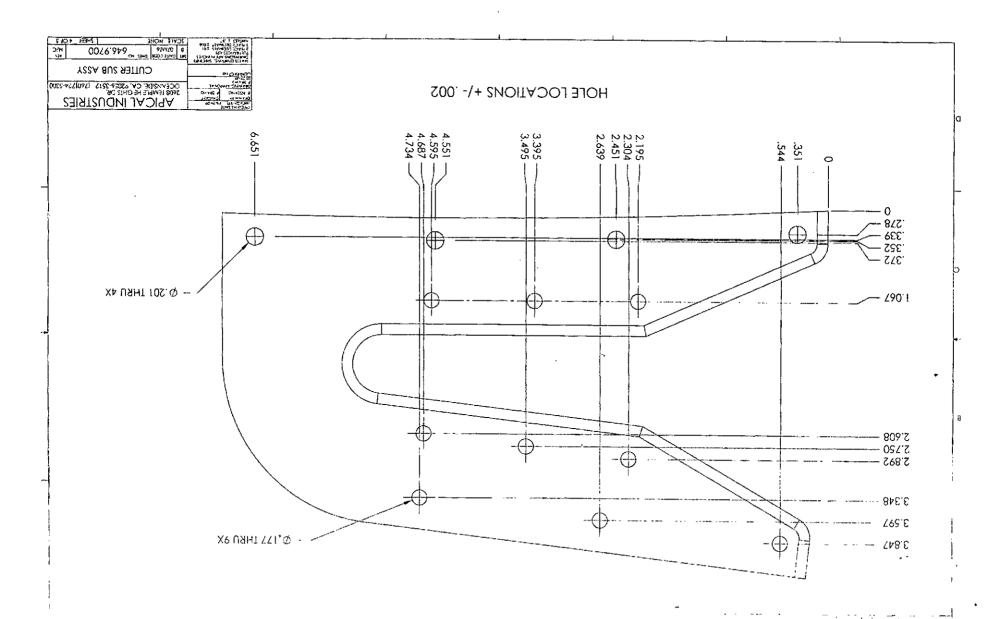
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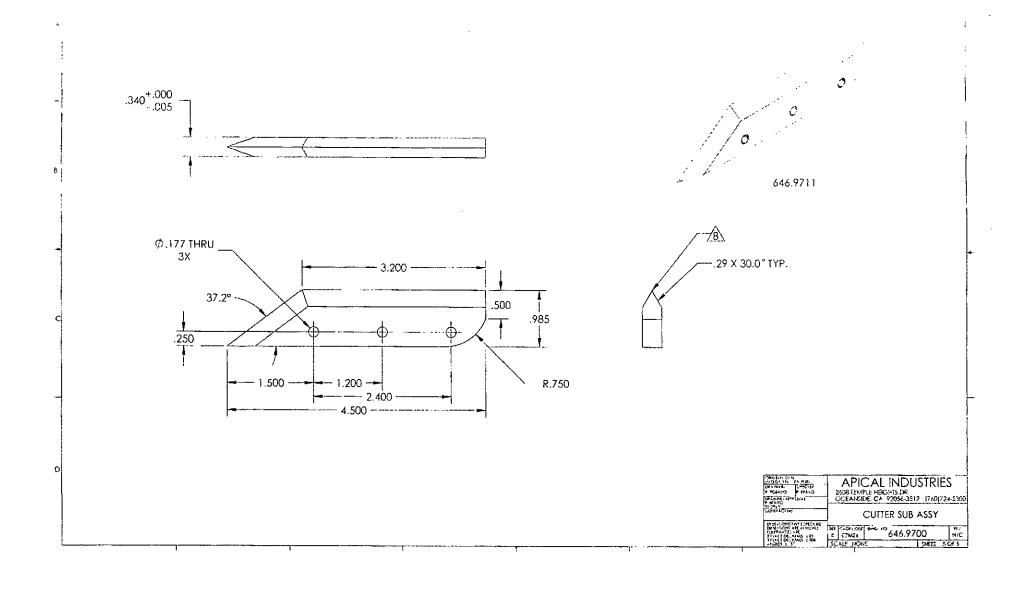
SECTION A-A 2/8

DACAMERITE MOSALIAY 017-01 DENATION LARCES PARANO PARANO	APICAL IN	DR.	
PANEL - PAREVAL	OCFANSIDE, CA. 9235	4-3512 (760)79 e	53.0
COLL OF	CUTTER S	UB ASSY	
UNITED CHARGE MEDICAL CHARLES AND TETRICAL TOLEPHARMEN AND TRUCK DECEMBER 201	E 07M/A 646	5.9700	#4- 11/C
TATACCTECCAL TOO	CEASE MONE	Transport Av	

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DART AEROSPACE LTD	Work Order:	98918
Description: BODY	Part Number:	646.971D
Inspection Dwg: 646.9700 Rev: D/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.467	±,005	1.467			H-6-	31006
R.250	±.005	R.250			R-6-	
7.026	±.005	7.027			74-6-	3/00%
10 X 45.0°	=. DID /= 1/2°	100X45.8			Dela	ML-DL
. 875	2.005	.878			- 11	10
,13 × 45.0°	±.010/=1/2°	.132X45.11			(1)	(,
.352	4.005 -000	.354			17	"
4.245	±.005	2.244			H-G	3100%
lolot	=.005	.660	سر		/1	, , , , , , , , , , , , , , , , , , ,
660	±.005	.658				
·70D	± 005				Vem	71-02
.278	±.802	.277		,	14-6-	31001
1.067	±. 202	1.066			71	
2.892	±.002	2.891				
3.847	±.002	3.845			11	
,351	±.002	,35,2			11	
2.639	±.002	2.241			11	
4,734	±.002	4.736			r f	
4.657	±.000	6.451			1/	
8.177	1.005 DDI				11 pm	71-04
10.20	±.005 001			<u></u>		11
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Measured by:	Audited by:	ÞΩ	Preliminary Approval:	
Date: 13/05/20	Date:	13/06/11	Date:	•

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

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A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62560

Date: 13-Aug-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ph: 613-632-5200 Fax: 613-632-1185 Ph: 613-632-5200 Fax: 613-632-1185 Terms Ship Via Quantity Description 1 Part: ASST Rev: lot 12 PCS 646.3010 14 PCS 646.3012 5_PCS_646.3310 51 PCS 646.9710 95 PCS 647.9711 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130500 PO: 20560 Line: Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY CERTIFIED SIGNATURE: RECEIVER SIGNATURE:

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♦ ₹				
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577 Fax: 613 632 1053 VC-ATG001 DUSTRIES INC. JUSTRIELLE ROAD ≟AND, ON K4K 1T2 1DA atact Name Buyer rendor Phone 613-446-4544 Ship To Contact Ship To Phone Ship-Via: FedEx Pl collect **FOB** Ship Acct:

646.9710 BODY

PURCHASE ORDER

Purchase Order ID PO20560

Purchase Order Date 7/12/2013 PO Print Date 8/14/2013

Page Number 3 of 3

DART AEROSPACE LTD Ship To:

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Chantal Lavoie

Customer POID Customer Tax #

10127-2607 Terms Currency

Net 30 CAD

Destination-Collect

Line Total:

\$739.5

\$739.:

647.9711 UPPER BODY

7/31/2013 Yes

7/31/2013

7/31/2013

7/31/2013

Yes

95.00

\$14.50

\$14.50

\$1,377.5

Line Total:

\$1,377.5

PO Total:

\$3,376.4

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer. No substitution or deviation without consent.

Certificate of Conformity or Material Certification required -(YES

PST# 6122-5207

4

Change Nbr:

98918 4

100355

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SAME AS ABOVE

SAME AS ABOVE

Change Date:

8/14/2013

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